

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015502**Date Inspected:** 08-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr.M.Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (9AW-9BW)**

This QA inspector performed a random visual survey inspection for flatness of transverse splice segment weld at Edge Panel Counter Weight Side on Segment 9AW to Segment 9BW with the following observations. The maximum out of flatness verified and measured was 12mm using a 600 mm Straight Edge across the Complete Joint Penetration (CJP) groove weld with single point contact. The surface flatness survey data was taken on the exterior side (flat side of the weld) of the Edge panel (Counter weight side). The allowable tolerance is 10mm. The Members are identified as follows:

9AW Edge Panel as EP111A, Counter Weight Side.

9BW Edge Panel as EP112A, Counter Weight Side.

Transverse Splice Weld identified as OBW9-001 between Panel Point (PP) 73 and PP 74.

An incident report was generated for the out of flatness observed on the edge panel transverse splice weld of segment 9AW to segment 9BW that exceeded the allowable tolerance of 10mm. See TL-6025 generated on this date for detailed information.

For additional information please reference the pictures below:

**OBG # OUTSIDE YARD (10AW)**

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This QA inspector along with QA inspector Mr.Manjunath S Math performed the dimensional survey inspection after heat straightening on the deck panel diaphragm to verify the flatness and plumbness on segment 10AW. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 10AW – PP 86

OBG # OUTSIDE YARD (10BW)

This QA inspector along with QA inspector Mr.Manjunath S Math performed the dimensional survey inspection after heat straightening on the deck panel diaphragm to verify the flatness and plumbness on segment 10BW. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 10BW – PP 89, PP 90 and PP 91

OBG # OUTSIDE YARD (10CW)

This QA inspector along with QA inspector Mr.Manjunath S Math performed the dimensional survey inspection after heat straightening on the deck panel diaphragm to verify the flatness and plumbness on segment 10CW. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 10CW – PP 92 and PP 94

OBG # TRIAL ASSEMBLY YARD (Lift 7E, 7W, 8E and 8W)

This QA inspector performed a visual inspection on the retrofit plates installed on the interior of the side and bottom panel. The inspection was performed to verify the fillet weld size, faying surface preparation and the exhibited angle on the retrofit flange. The relevant pictures were forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 7DE to Segment 7EE – E4 location (PP 58 to PP 59)

Segment 7AW to Segment 7BW – W4 location (PP 49 to PP 50)

Segment 7BW to Segment 7CW – W4 location (PP 52 to PP 53)

Segment 7CW to Segment 7DW – W4 location (PP 55 to PP 56)

Segment 7DW to Segment 7EW – W3 location (PP 58 to PP 59)

Segment 8AE to Segment 8BE – E4 location (PP 64 to PP 65)

Segment 8BE to Segment 8CE – E4 location (PP 67 to PP 68)

Segment 8AW to Segment 8BW – W3 location (PP 64 to PP 65)

Segment 8BW to Segment 8CW – W4 location (PP 67 to PP 68)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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